

Ship DEC. 11

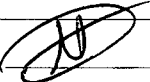
Work Order ID 138565

138565

Page 1

Tuesday, November 03, 2015 8:32:14 AM

Item ID: DSI 9603-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Basket Modification
 Start Date: 11/23/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/4/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: 11-11-03 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9603	B

100	DOCUMENT CONTROL	0.00	DAS 27 9-89			1	DAS 28 9-89	DEC 02 2015	
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPP DSI9603-011 CHG001							

110	Pick Kit	0.00					DAS 27 NOV 09 2015	SD	
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00					DAS 28 9-89		DEC 02 2015
120									
QC	Memo	0.00							
Quality Control									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 138565***138565***

Page 2

Tuesday, November 03, 2015 8:32:14 AM

Item ID: DSI 9603-011 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 12/4/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9603-011								
	Location: <u>PG</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SA 20151203

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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138565

DSI 9603-011

Required Date: 12/4/2015

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4017-9		Manufactured	No			110	Each	4.0000	4	4			
D4017-9									**			BAS 27 9-89	DAS 6 27 9-89
Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		4		B138438		2			
					138066	4				72			
D4623-1		Manufactured	No			110	Each	0.0000	7	7			
D4623-1									**			BAS 6 27 9-89	DAS 6 27 9-89
Bushing										138572			
D4623-3		Manufactured	No			110	Each	0.0000	6	6			
D4623-3									**			BAS 6 27 9-89	DAS 6 27 9-89
Bushing										138573			
D4624-1		Manufactured	No			110	Each	0.0000	1	1			
D4624-1									**			BAS 6 27 9-89	DAS 6 27 9-89
Mounting Plate										138574			
AN4-12A		Purchased	No			110	Each	107.0000	7	7			
AN4-12A									**			BAS 6 27 9-89	DAS 6 27 9-89
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		10							
					120423	10							
				ST344		97							
				m131957		97							

NOV 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

Tuesday, November 03, 2015 8:32:24 AM

Page 2

Work Order ID: 138565

138565

Parent Item: DSI 9603-011

DSI 9603-011

Parent Item Name: Basket Modification

Start Date: 11/23/2015

Required Date: 12/4/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-14A

Purchased

No

110

Each

257.0000

6

6

AN4-14A

Bolt

DAS

27

9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

250

M133284

100

M133316

150

ST344

2

M133011

2

NAS1149D0463J

Purchased

No

110

Each

5,266.000

26

26

NAS1149D0463.J

WASHER

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

626

M129390

41

M132035

585

ST260a

3198

M133284

1698

M133316

1500

ST269

1442

M129682

47

M130799

371

M132317

101

M132677

888

M133077

35

DAS

28

9-89

NOV 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, November 03, 2015 8:32:24 AM

Work Order ID: 138565

138565

Parent Item: DSI 9603-011

DSI 9603-011

Parent Item Name: Basket Modification

Start Date: 11/23/2015

Required Date: 12/4/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042-4

MS21042L4

Purchased

No

110

Each

1.0000

13

13

MS21042-4

Nut / use MS21042L4

Location

Loc Qty

Loc Code

ST305

1

9063

1

m13363

13

DAS

27

9-89

NOV 09 2015

DAS

28

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 REV. D

REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: 10016996

1.0 PURPOSE

This Dart service instruction provides parts and instructions for modifying the basket base assembly of a D350-607-545/-547 Heli-Utility-Basket for installation of scanning equipment.

The DSI 9603-011 kit consists of parts required to modify the basket base assembly of D350-607-545/-547 Heli-Utility-Basket.

The DSI 9603-013 kit is an optional liner kit for customers who wish to add some protection for the equipment that will be installed inside the basket. Customers who wish to procure DSI 9603-013 kit for their D350-607-547 Heli-Utility-Basket modified with DSI 9603-011 must convert their D350-607-547 Heli-Utility-Basket into a D350-607-545 Heli-Utility-Basket using the D350-607-415 Kit. Note that the DSI 9603-013 kit is not waterproof.

2.0 MODIFICATION PROCEDURE (DSI 9603-011):

- 2.1 Disassemble basket and retain hardware.
- 2.2 Locate the D4017-9 Ribs as shown in Figure 1. It is acceptable to trim the D4017-9 Ribs to fit as required.
- 2.3 Transfer mark the location of D4017-9 Ribs onto expanded metal. Ensure there is enough surface contact of the expanded metal strands with the new D4017-9 Ribs.
- 2.4 Trim expanded metal. Remove finish locally on expanded metal and basket base structure where the new D4017-9 Ribs and D4623-1/-3 Bushings will be added.
- 2.5 Weld the new D4017-9 Ribs to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 2.6 Cut center rib. Ensure removal of the center ribs will not damage the attaching ribs of the basket structure.
- 2.7 Locate and weld in place the D4623-1/-3 Bushings as shown in Section A-A.
- 2.8 Tig weld (tack weld) the expanded metal strands to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 2.9 Ensure there is no weld flashings in D4623-1/-3 by cleaning the ID of the bushings with a size 'F' drill ($\phi 0.257$) as required.
- 2.10 Mask ID of D4623-1/-3 Bushings and touch up powder coat of affected areas on the base with white powder coat (4.3.5.2) per Dart QSI 005 4.3 or in accordance with ICA-D350-607.
- 2.11 Modify D4624-1 Supporting Plate per Sheet 3 of this service instruction. Mount D4624-1 plate at the bottom of basket base assembly as shown on Sheet 4 of this service instruction.
- 2.12 Re-assemble basket per ICA-D350-607. Replace any worn hardware as necessary.

3.0 CUTOUTS FOR CAMERAS/LASERS

The following restrictions apply when using/loading the D350-607-545/-547 Heli-Utility-Basket modified per this service instruction:

- 3.1 Cutouts for lasers/cameras that do not exceed half the hatched area of Figure 2 are allowed in the hatched areas. These cutouts must be sealed for flight with a laser/camera.
- 3.2 Lasers/cameras can be mounted to the D4624-1 Plate using appropriate hardware.
- 3.3 After drilling holes/cutouts, touch up finish with alodine and paint D4624-1 using MIL-P-85582 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint.
- 3.4 These instructions do not approve any electrical/electronic modifications required in the aircraft to operate the equipment in the basket.
- 3.5 If a basket modified per DSI 9603 is going to be used to carry loose cargo the cutouts in the D4624-1 Supporting Plate must be covered with blanking plates.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	15.01.07
CERT. NO.:	SH94-14
ISSUE NO.:	6

B	REVISE PARAGRAPH 1.0: EXTEND APPLICABILITY OF DSI 9603-011 TO D350-607-547; ADD COMMENT TO CONVERT D350-607-547 TO -545 FOR FULL INSTALL OF DSI 9603-013	MB	15.01.07
A	NEW ISSUE	MB	12.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. REV. B DSI 9603 SHEET 1 OF 6	
CHECKED		TITLE SCALE BASKET MODIFICATION NTS	
MFG. APPR.	N/A	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED			
DE APPR.			
DATE	15.01.07		

4.0 INSTALLATION OF LINERS (DSI 9603-013):

- 4.1 Locate the D4628-9 Cover Plate as shown in Figure 3. It is acceptable to trim the D4628-9 to fit as required.
- 4.2 Remove finish locally on basket base structure where the D4628-9 Cover Plate will be added.
- 4.3 Weld the new D4826-9 to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 4.4 Touch up powder coat of affected areas on the base with white powder coat (4.3.5.2) per Dart QSI 005 4.3 or in accordance with ICA-D350-607.
- 4.5 Locate liners as indicated in Figure 3 (basket base) and Figure 4 (basket lid) of this service instruction.
Note: it is acceptable to trim the D4628-1/-3/-5/-7 liners to fit as required.
- 4.6 Locate and drill $\phi 0.257 - \phi 0.281$ " hole through D4628-1/-3/-5/-7 in center of the void of the mesh approx as shown. Deburr.
- 4.7 Secure D4628-1/-3/-5/-7 to basket mesh base/lid using provided AN4 hardware.
- 4.8 As required, it is acceptable to use more AN4 hardware (not supplied).

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9603-011	BASKET MODIFICATION
	X	DSI 9603-013	LINER
4		D4017-9	RIB
7		D4623-1	BUSHING, SHORT
6		D4623-3	BUSHING, LONG
1		D4624-1	MOUNTING PLATE
	2	D4628-1	LINER, FACE
	1	D4628-3	LINER, INBOARD
	1	D4628-5	LINER, OUTBOARD
	9	D4628-7	LINER, LID
	2	D4628-9	COVER PLATE
	98	AN4-4A	BOLT
7		AN4-12A	BOLT
6		AN4-14A	SCREW
	196	AN970-4	WASHER
13	98	MS21042-4	NUT
26		NAS1149D0463J	WASHER (OR NAS1149D0432J)

6.0 WEIGHT CHANGE:

This modification adds up to 35 lbs (20 lbs from DSI 9603-011 kit + 15 lbs from DSI 9603-013 kit) to the weight of the basket which reduces the cargo carrying capacity of the basket by up to 35 lbs depending on the amount of material removed from the D4624-1 Supporting Plate. See Figure 2 of sheet 4. It is the responsibility of the installer to ensure the limitations of FMS-D350-607 and FMS-D355-607 are not exceeded.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.07
CERT. NO.: SH94-14
ISSUE NO.: 6

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. DSI 9603	REV. B
MFG. APPR.	N/A	SHEET 2 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION	NTS
DATE	15.01.07	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

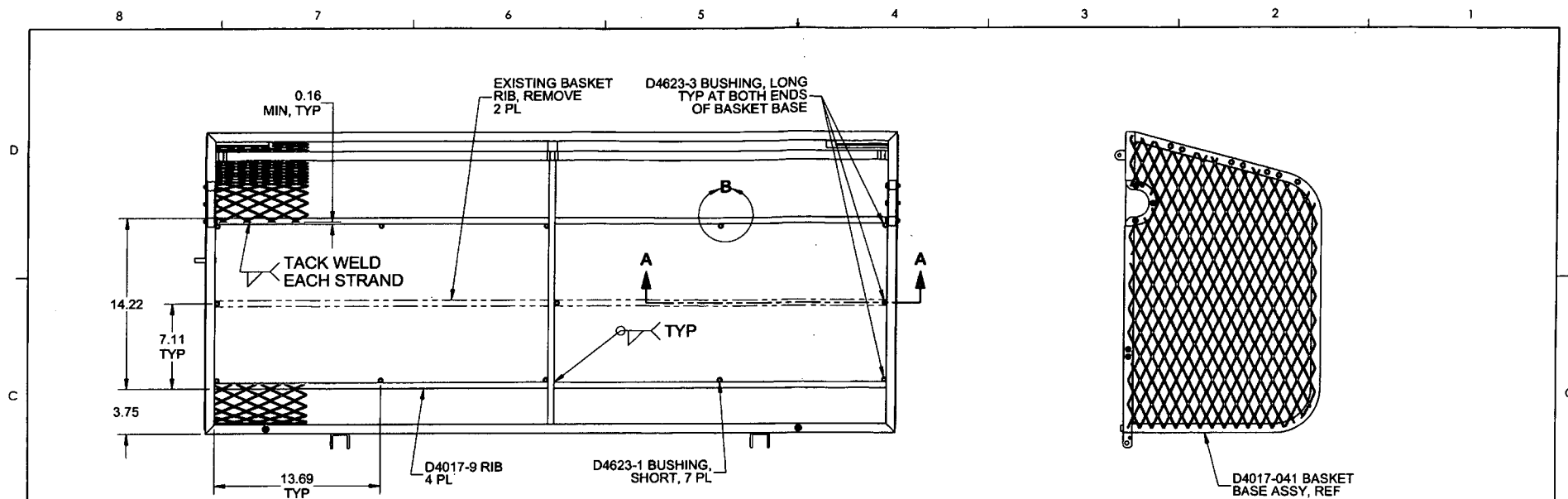
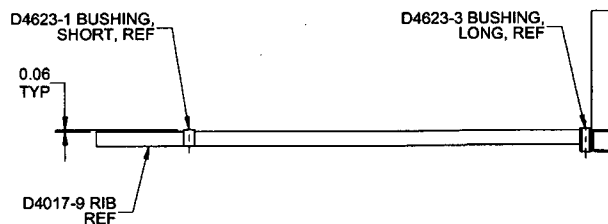
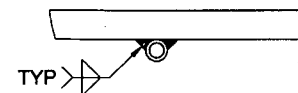


FIGURE 1: MODIFYING THE D4017-041 BASKET BASE ASSY
(MESH SHOWN PARTIALLY FOR CLARITY)



SECTION A-A: BUSHING DETAIL
SCALE 2X



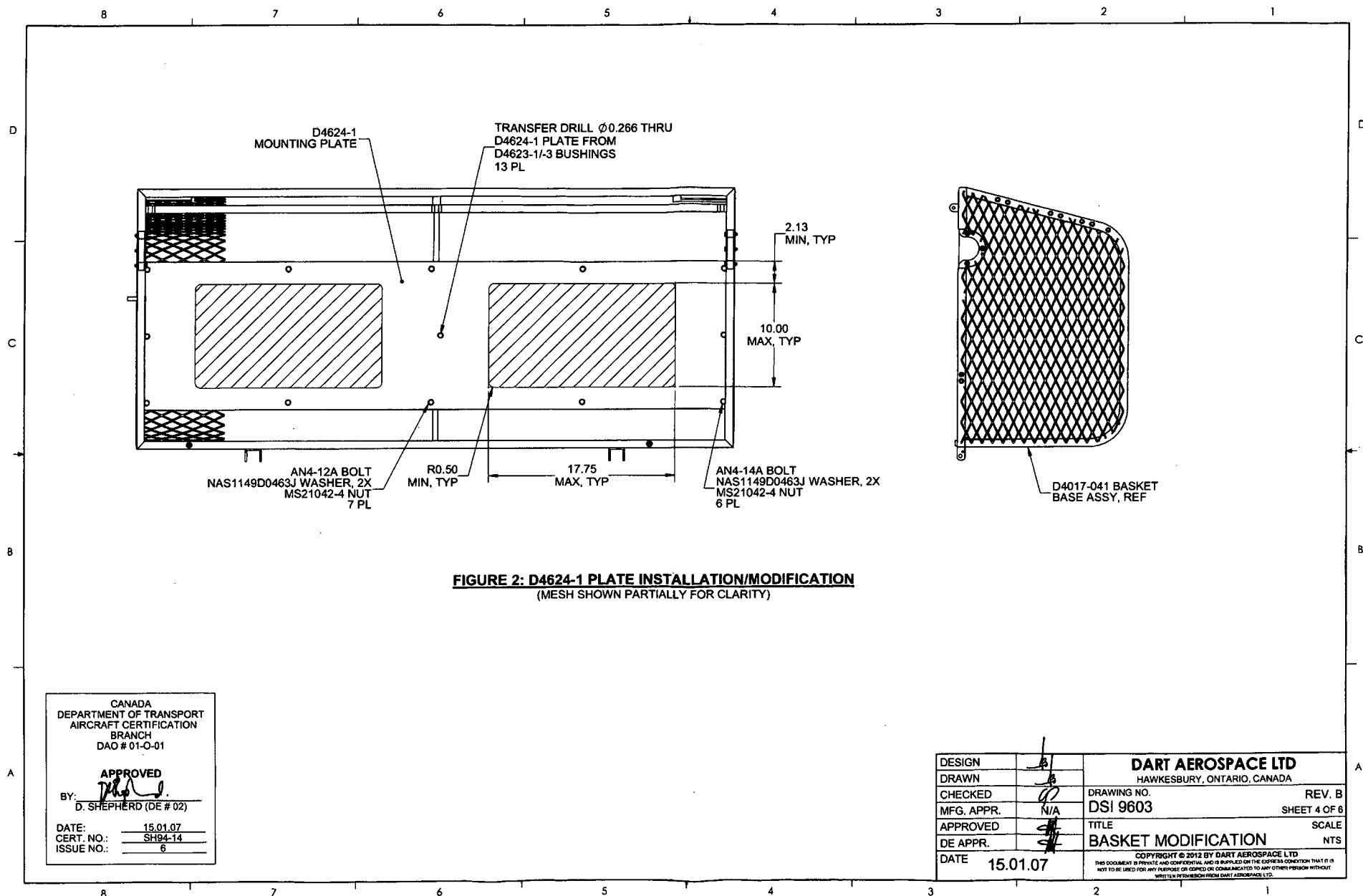
DETAIL B: WELDING DETAIL
SCALE 4X

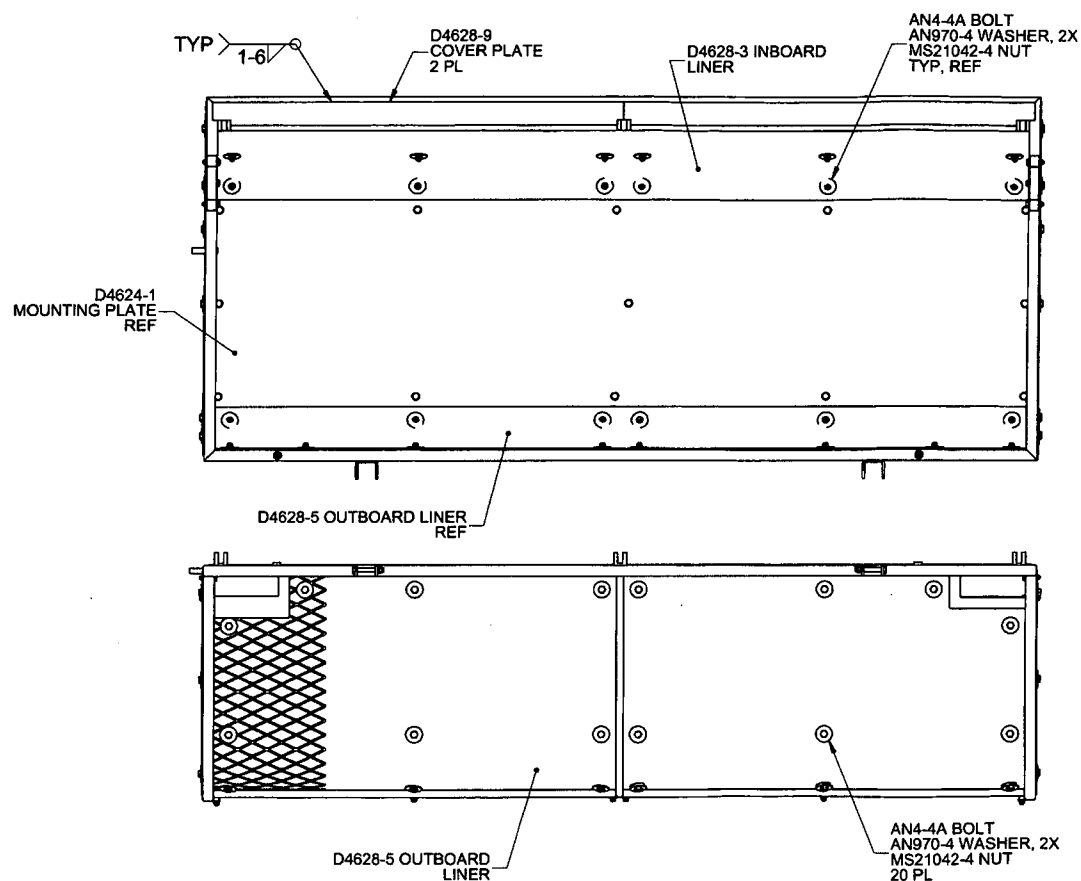
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DAO # 01-O-01

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BY: *[Signature]*
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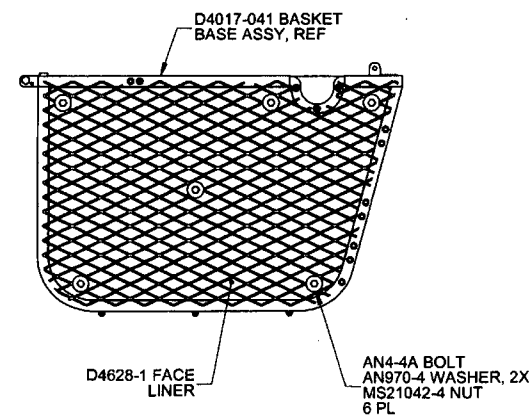
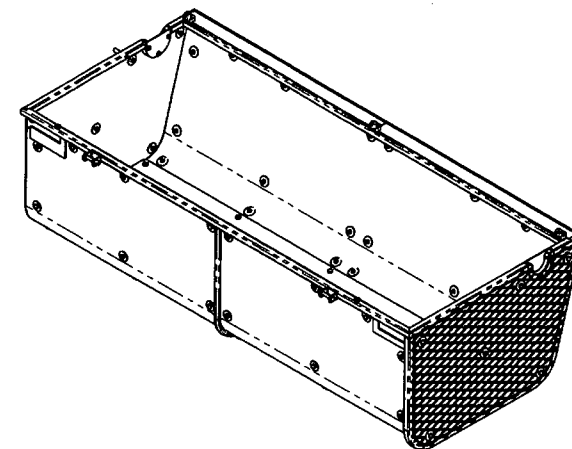
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DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	DSI 9603	SHEET 3 OF 6
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INSTALLATION OF D4628-3/-5 LINERS
(D4628-5 SHOWN, D4628-3 SIMILAR)

FIGURE 3: INSTALLATION OF DSI 9603-013 LINER KIT - BASKET BASE
(VIEWED FROM TOP, MESH SHOWN PARTIALLY FOR CLARITY)



INSTALLATION OF D4628-1 LINER
(OPPOSITE FACE SIMILAR)

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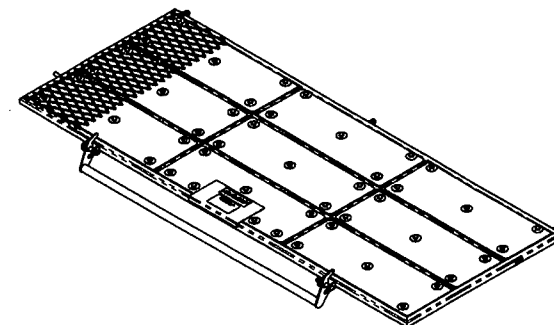
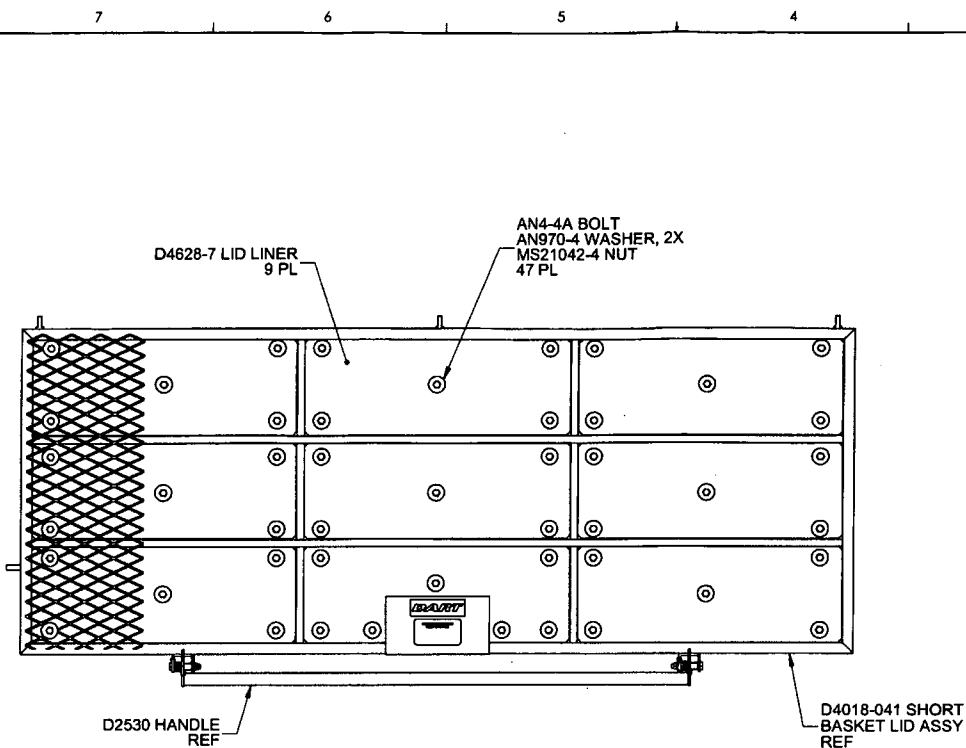


FIGURE 4: INSTALLATION OF DSI 9603-013 LINER KIT - BASKET LID
(VIEWED FROM TOP, MESH SHOWN PARTIALLY FOR CLARITY)

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28
9-89

4.0 INSTALLATION OF LINERS (DSI 9603-013):

- 4.1 Locate the D4628-9 Cover Plate as shown in Figure 3. It is acceptable to trim the D4628-9 to fit as required.
- 4.2 Remove finish locally on basket base structure where the D4628-9 Cover Plate will be added.
- 4.3 Weld the new D4826-9 to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 4.4 Touch up powder coat of affected areas on the base with white powder coat (4.3.5.2) per Dart QSI 005 4.3 or in accordance with ICA-D350-607.
- 4.5 Locate liners as indicated in Figure 3 (basket base) and Figure 4 (basket lid) of this service instruction.
Note: it is acceptable to trim the D4628-1/-3/-5/-7 liners to fit as required.
- 4.6 Locate and drill $\phi 0.257$ - $\phi 0.281$ " hole through D4628-1/-3/-5/-7 in center of the void of the mesh approx as shown. Deburr.
- 4.7 Secure D4628-1/-3/-5/-7 to basket mesh base/lid using provided AN4 hardware.
- 4.8 As required, it is acceptable to use more AN4 hardware (not supplied).

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9603-011	BASKET MODIFICATION
	X	DSI 9603-013	LINER
4		D4017-9	RIB
7		D4623-1	BUSHING, SHORT
6		D4623-3	BUSHING, LONG
1		D4624-1	MOUNTING PLATE
	2	D4628-1	LINER, FACE
	1	D4628-3	LINER, INBOARD
	1	D4628-5	LINER, OUTBOARD
	9	D4628-7	LINER, LID
	2	D4628-9	COVER PLATE
	98	AN4-4A	BOLT
7		AN4-12A	BOLT
6		AN4-14A	SCREW
	196	AN970-4	WASHER
13	98	MS21042-4	NUT
26		NAS1149D0463J	WASHER (OR NAS1149D0432J)

6.0 WEIGHT CHANGE:

This modification adds up to 35 lbs (20 lbs from DSI 9603-011 kit + 15 lbs from DSI 9603-013 kit) to the weight of the basket which reduces the cargo carrying capacity of the basket by up to 35 lbs depending on the amount of material removed from the D4624-1 Supporting Plate. See Figure 2 of sheet 4. It is the responsibility of the installer to ensure the limitations of FMS-D350-607 and FMS-D355-607 are not exceeded.

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Ship DEC. 11

Work Order ID 138565

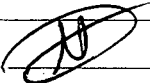
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Page 1

Tuesday, November 03, 2015 8:32:14 AM

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 Revision ID: Stop *NS2*
 Item Name: Basket Modification

Start Date: 11/23/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/4/2015 Req'd Qty: 1.00 *1* Customer:

Reference:
 Approvals: Process Plan:  Date: 11-11-03 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9603	B								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP DSI9603-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS

NOV 09 2015

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